

Date: Monday, 18/08/2008 3:44:10 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSY WELDMENT
Job Number :	41363		
Estimate Number :	13503		
P.O. Number :		Part Number :	PB674300109
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.6
First Issue :	1/1	Project Number :	N/A
Previous Run :	40772	Drawing Revision :	B1
Written By :		Material :	
Checked & Approved By :	<u>J. Lecocq 8.18</u>	Due Date :	18/09/2008
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

2
 11. m
 5
 18 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PB6743001211	Square Tubing
-----	--------------	---------------



12



Comment: Qty.: 6.0000 Each(s)/Unit Total: 48.0000 Each(s)

Square Tubing

batch:- 341487

C/L 08.10.20

2.0	PB6743001209	Square Tubing
-----	--------------	---------------



7



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tubing

batch:- ~~341487~~ x 2m 13 40595 x 2m

C/L 08.10.20

3.0	PB6743001201	Square Tubing
-----	--------------	---------------



84



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Square Tube

batch:- 241572

C/L 08.10.20

4.0	PB6743001203	Square Tube
-----	--------------	-------------



12



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tube

batch:- ~~40594~~ x 1m 41769

C/L 08.10.20

5.0	PB6743001239	Square Tube
-----	--------------	-------------



2



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tube

batch:- 241909

C/L 08.10.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 41363

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Outer Tube

batch:-

B41490

2

Cpl08-10-20

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Outer Tube

batch:-

B41489

2

Cpl08-10-20

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Flanged Hook

batch:-

B41488 4 mx. B41488

4

Cpl08-10-20

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Restraint

batch:-

B41211

8

Cpl08-10-20 - Pat E.

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Contoured Hinge Arm

batch:-

B41499

4

Cpl08-10-20

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Handle Arm Extension

batch:-

B410241 2 mx. B410244

4

Cpl08-10-20

12.0

D34409

Tube Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tube Detent Clip Base

batch:-

B41205

4

Cpl08-10-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 41363

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s)

Bracket

batch:-

B41452

Cpl 08-10-20

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

SP 08.10.20

Cpl 08-10-20

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/21 (2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/21 (82)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320 OF
1:30

M-L 08/10/21

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/21 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Cpl 08-10-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 41363

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/23 *HL*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-22

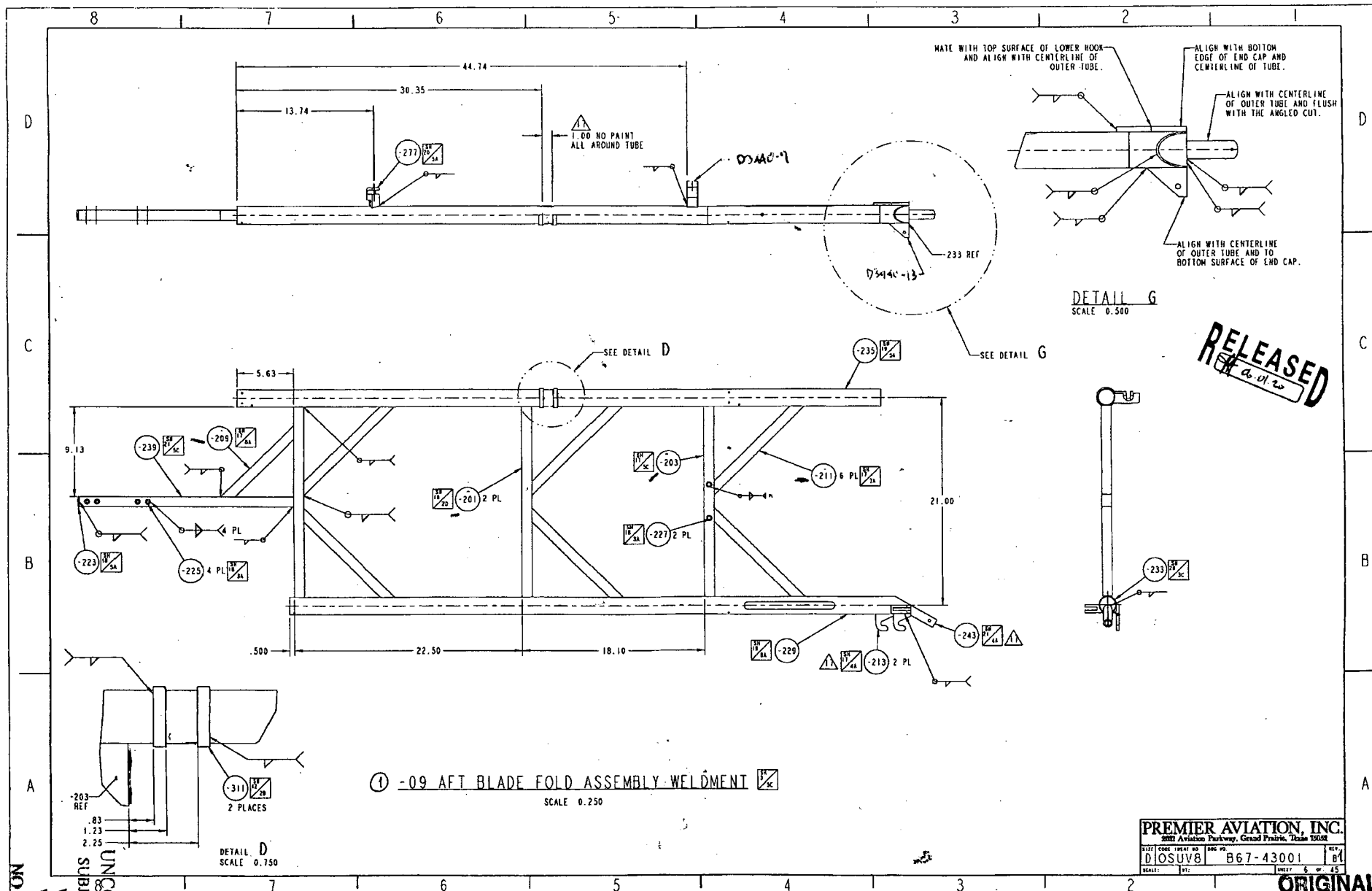
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75008

SIZE	CODE	INSTR	NO	DRW	NO	REV
D	OSUV8				B67-43001	81
SCALE:		PT:		SHEET		6 OF 45

ORIGINAL

NO. 41303

WORK ORDER

WITHOUT NOTICE

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

SHOP COPY

RETURN TO

ENGINEERING

15